



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2571
Job Sheet 179540



Part No: D2571

Job Qty: 8 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/25/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		7/25/18	0.00	0.00	Start Up Machining		SBL 18/07/17
100	CNC Vertical Machining	8 pcs		7/25/18	0.57	12.90	HAAS 1		SBL
110	Mill Conv	8 pcs		7/25/18	0.00	1.23	Mill Conv 1		SBL
120	QC	8 pcs		7/25/18	0.00	0.00	QC2		
130	QC	8 pcs		7/25/18	0.00	0.00	QC8		
140	HandFinish	8 pcs		7/25/18	0.00	0.27	HandFinish1		D.R 18/08-09
150	Powdercoat	8 pcs		7/25/18	0.00	0.32	Powdercoat1		lee 18.08.18
160	QC	8 pcs		7/25/18	0.00	0.00	QC3		DAS AUG 20 2018 38
170	Packaging	8 pcs		7/25/18	0.00	0.00	Packaging3	54397	6 AUG 23 2018 9-59
180	QC21-SA	8 Ea		7/25/18	0.00	0.00	QC21		9-89 21 AUG 24 2018

Part Op 100 - Program Batch No. 5092584 Double check by: JP 1-Machine Step No 1 per Folio FA051 and inspect per
Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA051 and inspect
110 - Machine keyway as per dwg D2571 & D2572
120 - Inspect on CMM as per folio CMM A022.
150 - START TIME: 8:00 PM FINISH TIME: 8:30 PM 326°

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	8 Ea (1 ea)	90-Start up Operation	5077236 5092583

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	8	45	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438	
2	Saddle, Fwd Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
3	Saddle, Fwd Outboard	3.495Inches	+ 0.010	3.505	

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework Scrap Use-as-is Suspected Unapproved	AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other
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Date : _____ Step #: _____ QTY Effective : _____

Description Work Order

QC / QA Coordinator
Approval

Lead hand / Supervisor
Approval Verification

Root Cause

Environment

Design

Doc/Data

Equip/Tooling

Handling/Pre

Material

Internal Transport

Tribal Knowledge

LOA

Substation

Past Expiry Date

Misidentified

No Re-verification

Operator

Offset/Setup

Supplier

Training

Use for Testing

Poor Information

Rushing

Product Improvement

Process Improvement

Manufacturing Process

Past Due

OTHER :

Positioned Wrong

Outside Dimensions

Over/Under tolerance

Part Incorrect

Part Lost/Missing

Part Moved

Drawing

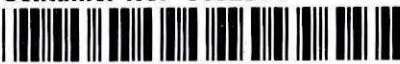
Finish

Misread

Turning Sequence

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DART
AEROSPACE

Container No: S092584

Part: D2571
Job No: 179540
Serial No/Batch: S092584
Revision:
Inspector:
Exp Date:
Instructions:

Date: 07/17/10

			- 0.000	3.495
4	Saddle, Fwd Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745
5	Saddle, Fwd Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Outboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Outboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000

36

Saddle, Fwd Outboard

0.023Inches + 0.020
- 0.000

0.043
0.023

Plex 6/20/18 8:31 AM dart.lacelle.linda

DART AEROSPACE LTD	Work Order: 192540	
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.004	8.003		
F	0.490	0.510		0.502	0.500	0.507	0.498		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.500	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.129	0.130	0.133	0.130		
Q	0.115	0.135		0.123	0.123	0.123	0.123		
R	0.240	0.260		0.250	0.250	0.250	0.250		
S	0.115	0.135		0.125	0.125	0.125	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.238	0.238	0.239		
W	0.115	0.135		0.120	0.118	0.120	0.117		
X	0.308	0.313		0.311	0.312	0.312	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.368	0.368	0.368	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.6250	0.627	0.617		
AC	0.053	0.073		0.063	0.058	0.058	0.060		
AD	0.240	0.260		0.249	0.249	0.249	0.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.125	0.125	0.124	0.130		
AG	0.240	0.280		0.250	0.260	0.260	0.250		
AH	0.240	0.260		0.240	0.240	0.240	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.038		

Accept/Reject

Measured by:	DAS
Date:	9-89 18/07/17

Audited by:	mm
Date:	18/08/04

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	179500
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.50	2.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.004	8.004		
F	0.490	0.510		0.506	0.503	0.505	0.507		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.502	0.504	0.498	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5685	0.573	0.5695	0.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.135	0.125	0.125	0.125		
Q	0.115	0.135		0.124	0.120	0.124	0.124		
R	0.240	0.260		0.250	0.250	0.250	0.250		
S	0.115	0.135		0.126	0.126	0.125	0.126		
T	0.178	0.198		0.188	0.188	0.1800	0.180		
U	2.940	2.980		2.960	2.960	2.960	2.96		
V	0.230	0.250		0.235	0.235	0.235	0.235		
W	0.115	0.135		0.120	0.118	0.120	0.120		
X	0.308	0.313		0.311	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.368	0.368	0.368	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.625	0.623	0.622		
AC	0.053	0.073		0.058	0.058	0.058	0.058		
AD	0.240	0.260		0.249	0.250	0.250	0.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.138	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.248	0.245	0.245	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	
Date:	

Audited by:	mmg
Date:	18/08/09

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
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